

Serial No. 10/657,169

**AMENDMENTS TO THE ABSTRACT**

Please replace the current Abstract with the following replacement/new Abstract

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#### ABSTRACT

In a friction stir welding method of manufacturing a piston for a variable capacity swash plate type compressor, the welder is shifted from the welded portions to a predetermined position while maintaining contact between the welder and one of the piston members. After finishing the friction stir welding, a hole is not formed in the welded portions of the piston members to improve durability of the welded portions. The piston members are elastically supported by support rollers to align the central axial lines of the piston members with the axial line of the chuck, even though the diameters of the piston members differ.